

Work Order ID 86956

86956

Page 1

July-09-12 2:59:59 PM

Item ID: D212-664-107

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Low Standard Fwd

Start Date: 7/06/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/06/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D212-664-147	Rev B (DEO)
--------------	-------------

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels as per PPP D212-664-107
D6019-128 (ID = 2.125") = CHG 002

0.00

0.00

110

110

Packaging

Packaging

Packaging

Memo

0.00

0.00

120

120

CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D212-664-107 using CNC bender program 212-107

0.00

0.00

DAS
15
2-89

12/10/31

MLJ 12-10-31

MO 12/10/22

MO / TCM 12/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

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Item Name: Crosstube Low Standard Fwd

Start Date: 7/06/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/06/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC15- Crosstube Dimensional Check

0.00

130

QC

Memo

0.00

Quality Control

140

0.00

140

Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Cut tube as per inspection dwg and deburr ends. ***ensure saw is square***

2-Position cuffs on tube ensure proper positioning

3-Drill tube as per dwg using DT8577 location #7 & # 212 ULF using jig DT8548 and DT8549 as per QSI 10

4-Transfer drill rivet holes from cuff into tube.

5-Identify cuff position and Batch # on each and identify tube as per dwg D212-664-107.

6- *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***
Inspect surface damage

7- Deburr and realodine cuff.

JW 12-10-23

RM/MD 12-10-24

JW 12-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Start Date: 7/06/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5 Memo	0.00 0.00				1			DAS 05 12 10 24
160 *160* HandFXtube Hand Finishing Crosstubes	Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1- CLEAN CROSSTUBE WITH WASH'N WIPE	0.00 0.00				1	0	0	12-10-25
180 *180* Outsource2 Outsource process - NDT	Outsource process - NDT per QSI038 4.1 Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: 18250 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	0.00 0.00							12-10-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 20		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Required Date: 7/06/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

0.00

190

Packaging

Packaging

Memo

0.00

Packaging

Ensure copy of NDT results attached to work order.

[Signature]

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

Inspect for damage & ensure results are as per Dwg D212-664-107

[Stamp: DAS 05 12 10 25]

202

0.00

202

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

1- PRESSURE WASH AND THEN USE WASHH'N WIPE TO CLEAN CROSSTUBE BEFORE CHEMICAL CONVERSION

[Stamp: 12-10-25]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 86956

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July-09-12 2:59:59 PM

Item ID: D212-664-107 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Crosstube Low Standard Fwd
 Start Date: 7/06/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
205 *205* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	0.00 0.00				1			DAS 05 12-10-26
210 *210* Crosstubes Crosstubes	Crosstubes Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Rivet Cuffs as per Dwg D212-664-147. with Sika flex in Between tube & Cuff A/R SIKAFLEX -241/-291 BATCH: <u>123025</u>	0.00 0.00				1	0	0	12-10-26
215 *215* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	0.00 0.00				1			DAS 05 12-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
27 30								

NOTE: Date & initial all entries

Work Order ID 86956***86956***

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N900040100Setup Start ***NS1***

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Item Name: Crosstube Low Standard Fwd

Start Date: 7/06/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/06/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00

220

SprayPaint

Spray Painting

SprayPaint

Memo

0.00

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 7:00Finish Time: 8:00

PAINT:

Start Time: 3:00Finish Time: 4:00

230

QC14- Inspect Spray Paint

0.00

230

QC

Quality Control

Memo

0.00

Wrap in plastic bag to protect from scratches

DAS
05
27

12-10-27

25 12-10-29 (X1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 86956

86956

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July-09-12 2:59:59 PM

Item ID: D212-664-107

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Low Standard Fwd

Start Date: 7/06/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/06/12

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

240

Crosstubes

Crosstubes

Crosstubes

Memo

1- Assemble as per Dwg D212-664-147

1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper,
clean the area with 4105S wash 'n' wipe

2-Install supports with Proseal 890 per DSI9563 and QSI 015

A/R Proseal 890 Batch: 123103

3- Torque bolts as per dwg

0.00

0.00

1

DAS
05
12 10 29

250

250

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS
16
17/10/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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 Item Name: Crosstube Low Standard Fwd
 Start Date: 7/06/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
255	Pick Kit	0.00							
255									
Packaging	Memo	0.00				1			12/10/31 JB
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00				1			
Quality Control									
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212-664-107								

DAS
15
9-89

12 10 31

Rec
63

12/10/31 SY

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 86956***86956***

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July-09-12 2:59:59 PM

Item ID: D212-664-107

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Low Standard Fwd

Start Date: 7/06/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/06/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/11/2012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

July-09-12 2:59:59 PM

Page 1

Work Order ID: 86956

Parent Item: D212-664-107

Parent Item Name: Crosstube Low Standard Fwd

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07.09.12 EC verified by: JLM
 IPP Rev:B ECN 1100 08-01-11 DD verified by: EC
 IPP Rev:C Ecn 1121 08-02-25 DD Verified by:ec IPP Rev:D 10.05.27 added pick kit
 DD verf:EC IPP Rev:E 11.10.17 added SEQ 215 DD verf:EC IPP
 REV:F 11.11.03 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664-107TRN Crosstube Turning Detail		Manufactured	No		B89858	140	Each	3.0000	1	1		MO 12/10/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		1							
				79679		1							
				LG046		2							
				79678		1							
				86053		1							
D3659-1 CUFF		Manufactured	No			220	Each	9.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST482	89261	9			2			MO 12/10/31	
				67005		1							
				75173		1							
				77032		7							
GR3212-4-06 CHERRY RIVET		Purchased	No			240	Each	372.0000	44	44		AR 12-10-26	
				<u>Location</u>	123346	<u>Loc Qty</u>		<u>Loc Code</u>	13				
				ST330		319							
				120521		119			32				
				122141		200							
				ST331		53							
				112492		18							
				112794		8							
				119717		27							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID: 86956

Parent Item: D212-664-107

Parent Item Name: Crosstube Low Standard Fwd

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 1.00

Required Qty: 1.00

D3595-063-450

Manufactured No

240

Each

105.0895

4

4

12 10 29

RUBBER CUSHION

Location

Loc Qty

Loc Code

LG 9.28
82511 9.28
LG051 85.7
80161 1.7
84715 84
MAT052 10.109474
67353 2
68893 6
70113 0.56
71354 0.2
74113 0.349474
75597 1

B# 90968

MS21920-25

Purchased

No

240

Each

136.0000

4

4

12 10 29

Clamp(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG050 117
116264 2
117998 4
118142 4
119339 2
119746 2
120475 7
120920 46
122204 50
LG051 19
121583 19

B# 122838

W/O:		WORK ORDER CHANGES					
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Work Order ID: 86956
 Parent Item: D212-664-107
 Parent Item Name: Crosstube Low Standard Fwd

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 1.00

Required Qty: 1.00

D2893-1 Manufactured No
 2.75 Support

240 Each 16.0000

2

2

12/10/29

13 87289

Location

Loc Qty

Loc Code

LG	9	
83056	9	
LG052	7	
72865	2	
80271	4	
82228	1	

D3428-1
 Placard

Manufactured No

260 Each 33.0000

390993 SP

Location

Loc Qty

Loc Code

ST042	33	
78933	2	
81881	9	
83582	10	
85228	12	

SMB

AN635A
 BOLT

Purchased No

260 Each 42.0000

4 m122416 SP

Location

Loc Qty

Loc Code

342	42	
121181	42	

SMB

AN636A
 Bolt

Purchased No

260 Each 47.0000

m122416 SP
 12-10-31

Location

Loc Qty

Loc Code

ST342	47	
118422	2	
119449	1	
120187	4	
120423	40	

SMB

W/O:		WORK ORDER CHANGES					
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Work Order ID: 86956

Parent Item: D212-664-107

Start Date: 7/06/12

Required Date: 7/06/12

Parent Item Name: Crosstube Low Standard Fwd

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Nut

Purchased

No

260

Each

491.0000

6

m122441SP ✓

SMD

Location

Loc Qty

Loc Code

ST300

491

117677

25

118384

3

118927

48

119075

215

120308

200

MS260JD616

Washer

NAS1149D0663J

Purchased

No

260

Each

0.0000

18

m123021 ✓

SMD

SP12-10-31.

July-09-12 2:59:59 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

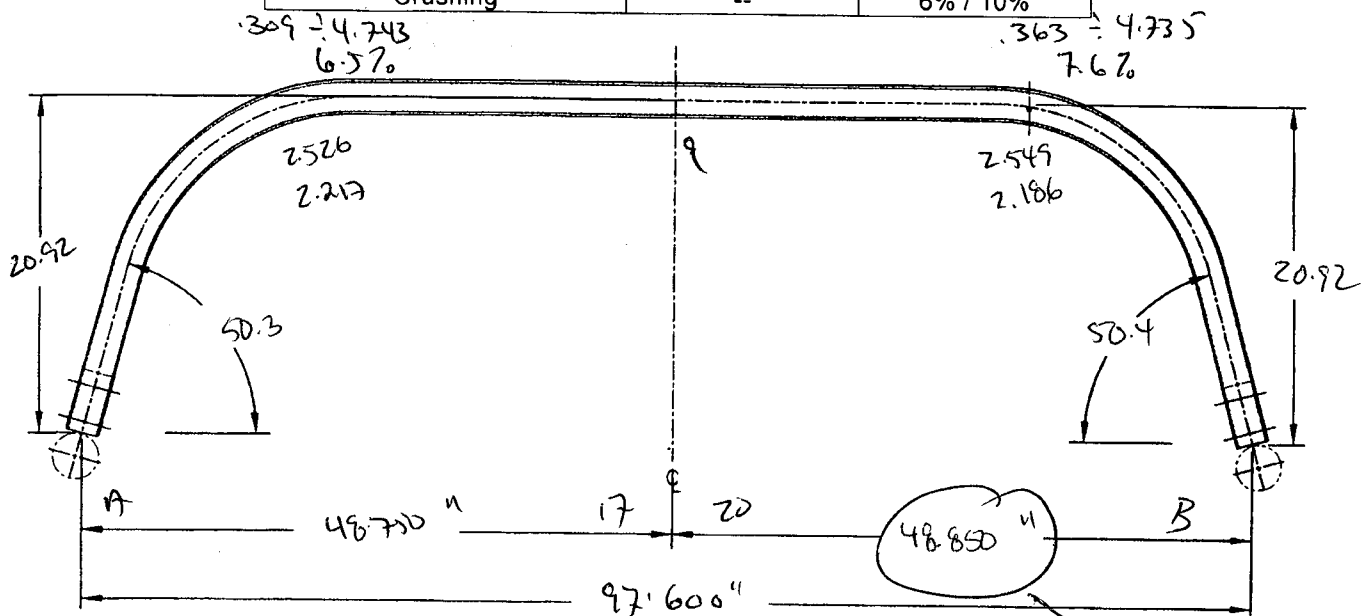
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	810956
Description: Crosstube Low Fwd (205/212/412)		Part Number:	D212-664-107
Inspection Dwg: D212-664-147	Rev: B	Page 1 of 1	

Required Dimension	Min	Max
Height	20.79	21.05
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62
Bending Passes	8	--
Crushing	--	6% / 10%



	Side A	middle	Side B
Bending Passes	17	9	20
Crushing	6.5%		7.6%
Comments			
Side A = 6.5% crushing @ 17 passes			
Middle = 9 passes			
Side B = 7.6% crushing @ 20 passes			

OK DAS
12/10/23

QC15 Inspection	DAS	DAS
Date	17/10/23	17/10/23

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	
B	10.01.21	Dwg Rev updated	KJ	
C	12.04.16	Added bending, crushing dimensions	KJ	

Dart Aerospace Ltd

W/O:		- WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -147	Qty -147B	Part Number	Description
1	X		D212-664-147	CROSSTUBE ASSEMBLY (205/212/412 LOW FWD)
2		X	D212-664-147B	CROSSTUBE ASSEMBLY (214 LOW FWD)
3	1	1	D6019-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	2	2	D3659-1	CUFF
7	4	4	MS21920-25	CLAMP (OR MS21920-26)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6019-128
FINISHED LENGTH = 126.528±0.020 (BEFORE BENDING/TRIMMING)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- WEIGHT: D212-664-147 = 24.2 lbs (PER IIN-D212-664)
D212-664-147B = 24.2 lbs (PER IIN-D212-664)
- PART IS SYMMETRIC ABOUT CENTERLINE
- WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD
BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%
BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER
INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.
DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE
UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS
NOT BOTTOMED-OUT AFTER TORQUING.
- INSTALL D3659-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF
SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.
SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86956 MLJ

12/07/10 DEO ATTACHED

Per EOW #1164
A 1107.26
UNDER REVIEW
11/18/13

RELEASED
2009-10-29
ND

B	REVISE GENERAL NOTES/PART LIST: UPDATE TO CURRENT STANDARDS: ADD -147B (ZN C4-2, D4-2)	RF	09.09.30
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	9P	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9P	DRAWING NO.	REV. B
MFG. APPR.	18	D212-664-147	SHEET 1 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	14	CROSSTUBE (205/212/412 LOW FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE COPIED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

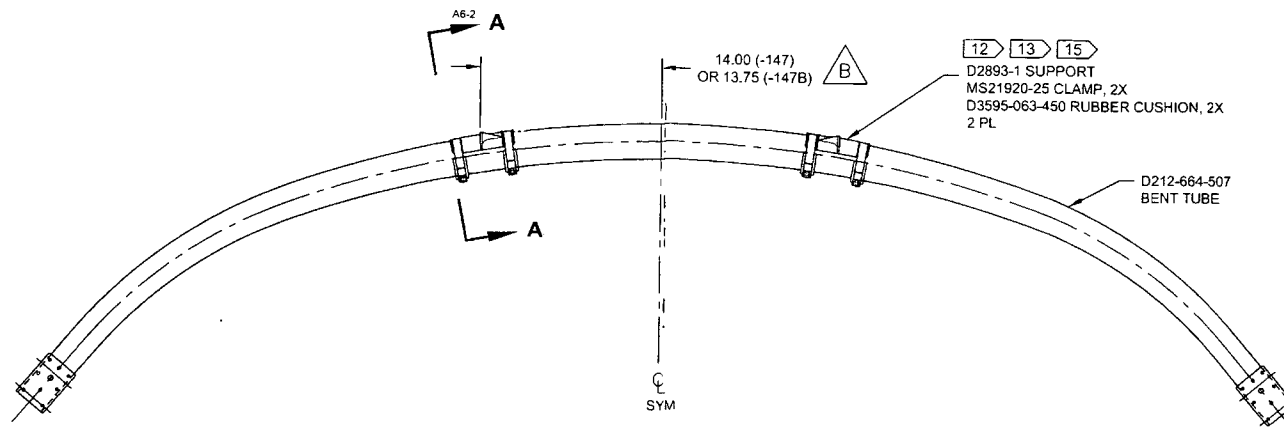
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

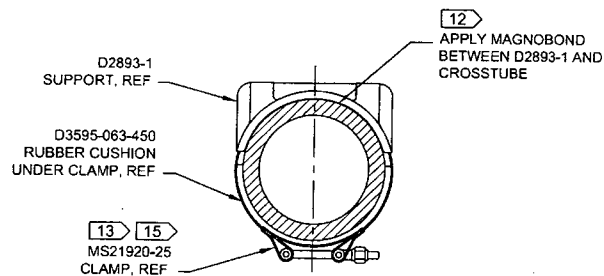
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D212-664-147/-147B
ASSEMBLY DETAIL



SECTION A-A D5-2
SCALE 4X

86956

DEO ATTACHED

ECU #11-614
K.09.28
UNDER REVIEW
CP 11.26.13

RELEASED
2009-10-29

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D212-664-147	SHEET 2 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (205/212/412 LOW FWD)	NTS
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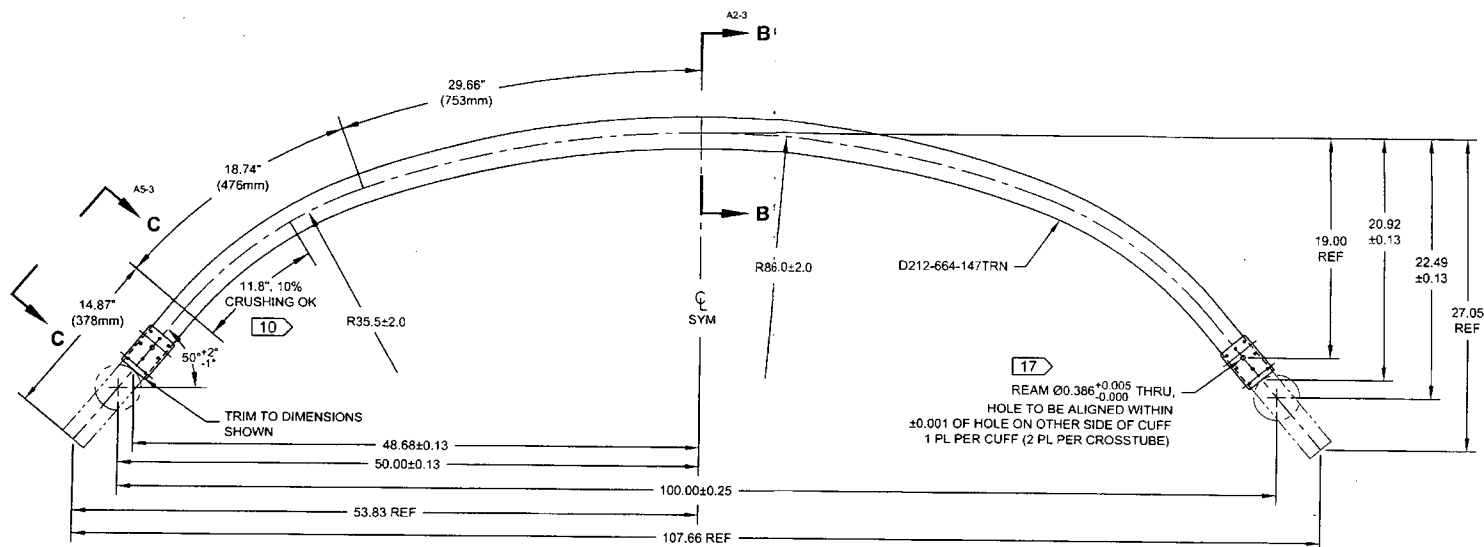
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

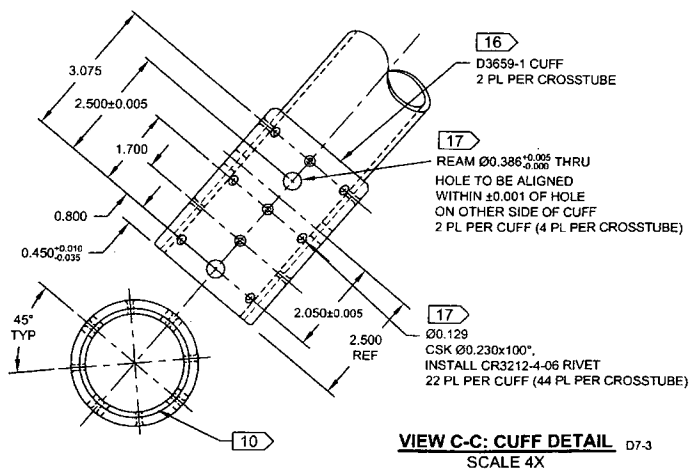
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

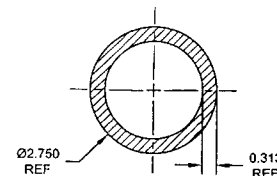
NOTE: Date & initial all entries



D212-664-507
BENDING AND DRILLING DETAIL 10 B



VIEW C-C: CUFF DETAIL 07-3
 SCALE 4X



SECTION B-B D5-3
 SCALE 4X

ECN #11-614
 09.07.28
 UNDER REVIEW
 09/04/13

RELEASED
 2009-10-28

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. B
MFG. APPR.	15	D212-664-147	SHEET 3 OF 4
APPROVED	90	TITLE	SCALE
DE APPR.	15	CROSSTUBE (205/212/412 LOW FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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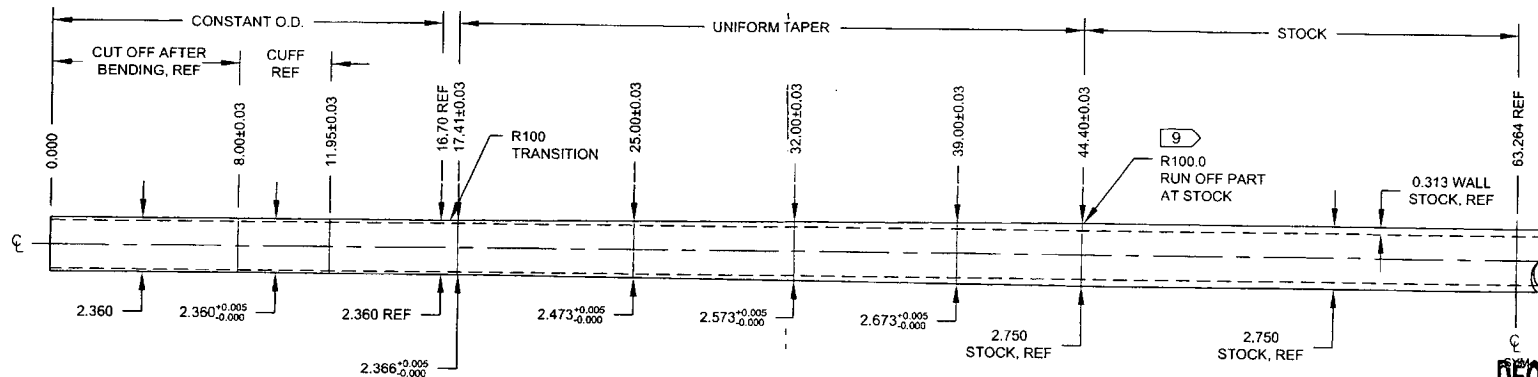
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D212-664-147TRN
TURNING DETAIL**

DEO ATTACHED

ECO #1-614
11.07.26
UNDER REVIEW
R. J. G. 13

RELEASED
2009-10-29

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D212-664-147	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (205/212/412 LOW FWD)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D212-664-147	TITLE CROSSTUBE ASS'Y (205 LOW FWD)	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-147-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>90</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>18</i>	APPROVED <i>MP</i>		DE APPR. <i>14</i>		
DATE 11.07.15	DATE <i>11.07.20</i>	DATE <i>11.07.21</i>	DATE <i>11/07/21</i>		DATE <i>11.07.21</i>		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -147	Qty -147B	Part Number	Description
9	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTROM/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	-----	----------------	---

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2893-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-07-28
VW

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 10177

PAGE 1 OF 1

CLIENT Dart Aerospace DATE Oct 25 2012 TIME AM ☒ PM ☐
ATTENTION Chantale, Linda, Andy ACUREN JOB NO. 188-12-C0508
ADDRESS 1270 Aberdeen St PO/WO No. 18250
Hawkesbury, on WORK LOCATION As address
ACCEPTANCE STD. ASTM 1417/AST 200 REV./DATE 2005
PROJECT PT-Wet Fluorescent Liquid Penetrant Inspection
ITEM(S) EXAMINED - See Below

JOB DESCRIPTION PROCEDURE NO. LT-002 REV./DATE 2009 TECHNIQUE NO. LT-002 REV./DATE 2009

PART NO. MATERIAL Aluminium 1/2/5 THICKNESS -
SCOPE Performed a wet Fluor. L.P.I on 100% of the external surface on Items mentioned below

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND Magnaflux BLACK LIGHT S/N 13790 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2L-6T MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER MINIMUM DRY TIME >10 MIN. OTHER
DEVELOPER SKD-S2 MINIMUM DWELL TIME 30 MIN. LIGHT METER S/N 1098866 CAL DUE DATE Oct 20 2012
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < - 4°C/ 20°F ☐ - 4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

1	Cross tube	WOID 86955	✓
2	Cross tube	WOID 86956	✓
3	Cross tube	WOID 87390	✓
4	Cross tube	WOID 89391	✓
5	Tube APT	WOID 92051	✓
6	Tube Fwd	WOID 92052	✓
7	Cross tube Ins	WOID 81522	✓

ITEM ID 0212-664-107 Fwd
ITEM ID 0212-664-107 Fwd
ITEM ID 0212-664-107 Fwd
ITEM ID 0212-664-107 Fwd
ITEM ID 04139-3
ITEM ID 04139-1
ITEM ID 0350-748-201 APT

No relevant indication was detected to per applicable standards at the time of inspection.

12 10 25

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE <u>Andy Shelden</u> PRINT	<u>AShelden</u> SIGNATURE	DTR # <u>E-120876</u>
TECHNICIAN (SIGNATURE): <u>Alexandre Michard</u>		REPORT REVIEWED BY:
NAME (PRINT): <u>Alexandre Michard</u>		NAME INITIALS
CGSB LEVEL <u>II</u> SNT LEVEL <u>II</u>	CGSB LEVEL SNT LEVEL	
CGSB REG. NO <u>10148</u>	CGSB REG. NO	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

PT Sept 2005